Date

Thursday, 4/12/2007 9:33:48 AM

User:

Kim Johnston

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 31786

**Fstimate Number** 

: 10599

P.O. Number

NIA

This Issue

Prsht Rev.

First Issue

Written By

Previous Run

: 4/12/2007

MIM

S.O. No. : NA

: 30548

: SMALL /MED FAB Type

Checked & Approved By

Comment

: Est. est

61.06.08

ecn 822 С 06.12.13

Now laser cut EC

Due Date

Material

**Drawing Name** 

Part Number

**Drawing Number** 

Project Number

**Drawing Revision** 

- D2506 REV E

: LABEL PLATE

: D2506

: N/A

: 5/10/2007

25 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

Description:

1.0

M304S20GA

304/316 .040 Sheet

1.2810 sf(s)/Unit Total:

32.0250 sf(s)

304/316 .040 Sheet

H103-713 4 M104640

2.0

Batch: WATER JET

Comment: Qty.:



Comment: FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev:\_\_ Prog Rev:\_\_\_

2-Deburr if necessary

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0 QC8

SECOND CHECK



Comment: SECOND CHECK 5.0



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.



## **Dart Aerospace Ltd**

	WORK ORDER CHANGES							
STEP	PROCEDURE CHANGE	1.00	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		*						
				- H				
		4						
		- E				:		
	STEP	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr	

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: OHOHO
	4.0		QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
-		Description of NC		Corrective Action	Section B	120	Verification	Approval Chief Eng	Ammanal	
DATE	STEP	Section A	Initial Chief Eng	Action Descr Chief Eng	iption	Sign & Date	Section C		Approva QC inspecto	
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NOTE: Date & initial all entries

Thursday, 4/12/2007 9:33:48 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: LABEL PLATE Customer: CU-DAR001 Dart Helicopters Services Job Number: 31786 Part Number: D2506 Job Number: Seq. #: Description: Machine Or Operation: 6.0 BRAKE NC NC BRAKE Comment: NC BRAKE 1-Form as per dwg D2506 7.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 8.0 PACKAGING 1 PACKAGING RESOURCE #1. Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE CL07/07/09 Job Completion

## Dart Aerospace Ltd

<b>W</b> /O:			WORK ORDER CHANGES									
DATE	STEP	PROCEDURE	CHANGE	9	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #: Fault	Category:	NC	R: Yes	No DQA	<b>\</b> :	Date:				

QA: N/C Closed: \_\_\_\_

NCR:		•	WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B	Verification	Annroyal	Annroyal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Sign & Date	Section C	Approval Chief Eng	Approva QC Inspecto		
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31786
Description: Label Plate	Part Number:	D2506
Inspection Dwg: D2506 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.63	+/-0.030	32.625			MIT	
39.00	+/-0.030	39.00	~		M-T	
4.50	+/-0.030	4,502	/		Vern	
1.31	+/-0.030	1.315			Vern	
1.88	+/-0.030	1.874				
0.040	4 0.010	0.036	/		Vern	
					197	
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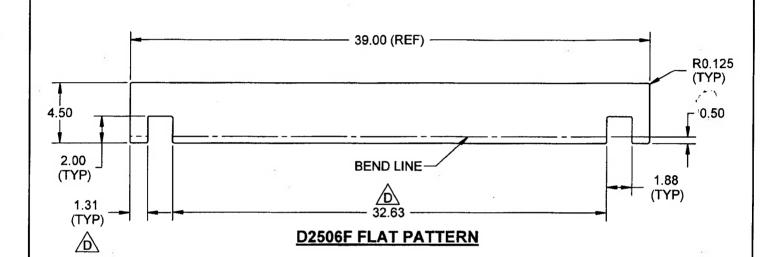
Measured by:	SAD	Audited by:	Ev	Prototype Approval:	N/A
Date:	07/06/24	Date:	07/de/25	Date:	N/A

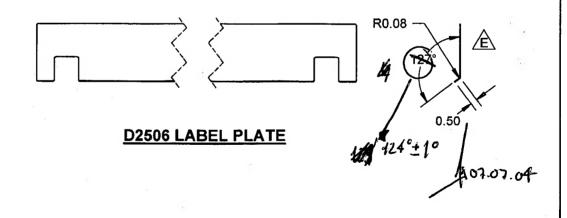
Rev	Date	Change	Revised by	Approved
- A	06.08.29	New Issue	KJ/JLM ,	1
В	06.12.20	Dwg Rev. updated	KJ/JLM	



DESIGN BW		DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
CHEC	KED	APPROVED:	DRAWING NO.	REV. E
	E	11	D2506	SHEET 1 OF 1
DATE			TITLE	SCALE
	06.1	06.11.20   LABEL PLATE \(  \)		1:7
REV		DATE	DESCRIPTION	
Α		95.11.26	NEWISSUE	
В		96.06.18	RE-DESIGN OF LABEL PLATE	
С		96.09.04	RE-DESIGN OF LABEL PLATE	
D		99.10.04	32.63 WAS 32.25; 1.31 WAS 1.50	
E		06.11.20	REMOVE 10* BEND; ADD NOTES; 1	27° WAS 126°

PELEASE





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NOTES:
1) MATERIAL: STAINLESS STEEL AISI 304/316 SHEET 0.040 THICK PER MIL-SEOTO OPY RETURN TO

(REF DART SPEC M304S20GA)

2) FINISH: NONE 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED UNCONTROLLED COPY

5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SUBJECT TO AMENDMENT

WITHOUT NOTICE